

ABSTRACT

Method and device for cutting out sheet metal blanks preferably from a coil (2) of a thin sheet metal strip (4), with stepped uncoiling and straightening of the metal strip (4) in the longitudinal direction of the device on a processing platform (10). In a first operation, the metal strip (4) is gripped above the processing platform (10) by a lateral clamping frame (14) and tensioned in the transverse direction relative to the feed direction. In a cutting position (6) the strip (4) is initially cut except for the webs that hold the blanks in the residual strip (4). The initially cut strip (4), still clamped, is then moved into a depositing position (7) above a depositing platform (12) by pull-out rollers (8) that tension the metal strip (4) in the longitudinal direction. The precut strip (4) and the cutting head(s) (15) are jointly moved into the depositing position where the cutting head(s) (15) that performed the main cutting operation severs the webs and the blanks are stacked in sorted fashion. Thereafter, the residual strip (4) is moved from the depositing position (7) to a disposal unit (9). The apparatus consists of a reel (1) that holds the coil (2) followed by a straightening unit (3) and by a cutting machine (5) with cutting heads (15), a cutting position (6) and a depositing position (7), followed by pull-out rollers (8) and finally by a disposal unit (9) that cuts up and collects the residual metal strip (4). Located in the cutting position (6) is a work support table (11) that supports the metal strip (4) unrolled from the coil (2). Located in the depositing position (7) is an elevating table (13) that supports the depositing platform (12) and can

be lowered to adapt to the deposited blanks. Located at the processing level between the cutting position (6) and the depositing position (7) is a movable clamping frame (14) that grips the metal strip (4), tensioning and holding it in the transverse direction relative to its feed direction in the cutting machine (5). Plates can be processed by clamping them in the frame at the processing station.